

Date: Thursday, 3/2/2006 3:07:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET, GAS SPRING STUD
Job Number : 26026	
Estimate Number : 10183	
P.O. Number : N/A	Part Number : D2154
This Issue : 3/2/2006 S.O. No. : N/A	Drawing Number : D2154 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>See COMMENT BELOW</u>	Due Date : 3/20/2006 Qty: 20 Um: Each
Checked & Approved By : <u>06.03.02</u>	
Comment : Est: C 03.08.08 Reformat; Remove Tumble KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 705

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D2154

Material release note is required

U 06-03-03

2.0	D2154F	Bracket, Stud
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 BRACKET, GAS SPRING STUD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

06-04-03 (20)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

06-04-04 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAN 06-04-04 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 26026

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SB 06/04/17

(19)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.04.17

15

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/04/19

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 9/4/20

(19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST26

P 9/4/20

(19)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/04/21

(19)

Job Completion


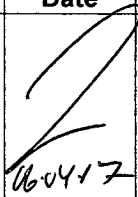
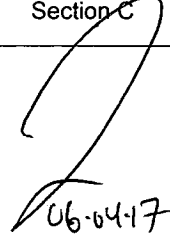
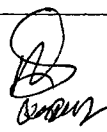
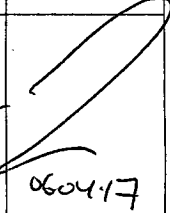


U 06/04/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

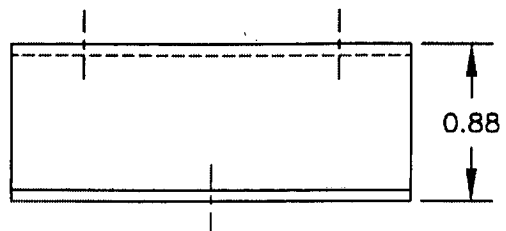
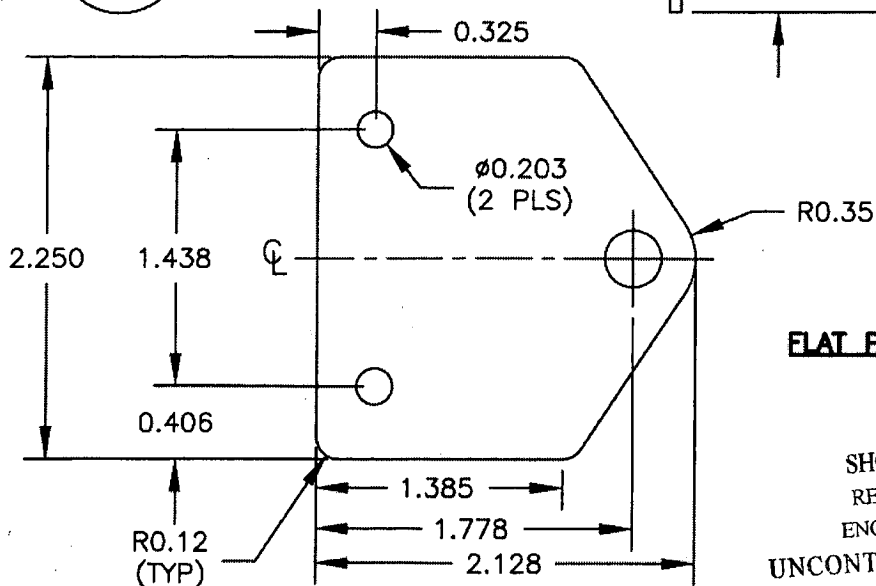
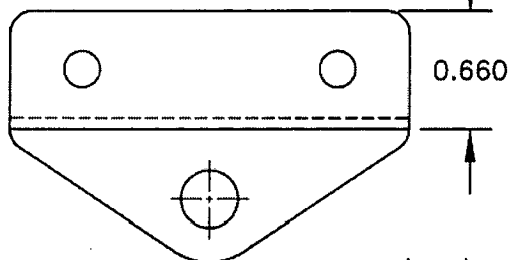
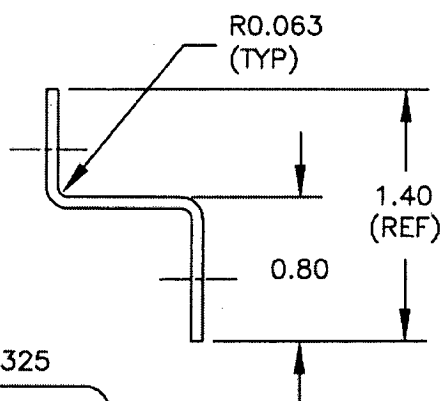
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 06/07/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-17	6	1 part missing ???		Qty 19.				

NOTE: Date & initial all entries

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26026*

Copyright © 1992 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

Corrosion: ASTM A262/01E; 180 Band-OK

Your Order: V033868

NAS Order: AE 0249852 03

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01, A480/01, A666/00, ASMESA240/01, SA480/01, SA666/01
QQS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	48.68	85.00	88.00

MILL

MILL TEST CERTIFICATES

705

870

YIEH MAU CORP.

ORIGINAL

INVOICE NO. : F05M920

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : OLBERT METAL SALES LIMITED

I.A.: 高雄縣新豐鄉新豐路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL: (07) 6972845 FAX: (07) 6978006
CERTIFICATE NO.: F05M920
DATE OF ISSUE: 10/28/2005

TOTAL P.04

SIZE	NO.	Weight (N.W.)		Heat NO.	ID NO.	Physical Properties Tensile Test CL=50mm					Chemical Composition (%)								
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK-PASS)																			
24GA / 48" X 96"	1	1,367	3,014	N8E53719	48S71574-12	268	641	68	78	150	6	37	72	25	6	804	1800	3.7	
24GA / 48" X 120"	1	1,149	2,533	N8E53719	48S71574-13	268	641	68	78	150	6	37	72	25	6	804	1800	3.7	
24GA / 48" X 120"	1	940	2,086	N8E53719	48S71574-14	268	641	68	78	150	6	37	72	25	6	804	1800	3.7	
16GA / 36" X 96"	1	1,899	3,084	YU235551	48S12437-315	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-313	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-314	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7	
16GA / 60" X 96"	1	1,360	2,976	YU139585	48S14145A-21	302	654	58	78	144	4.7	49	126	32	6	805	1822	3.1	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-13	306	647	51	80	155	4.8	53	112	31	6	805	1832	3.1	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-14	306	647	51	80	155	4.8	53	112	31	6	805	1832	3.1	
14GA / 48" X 96"	1	1,884	3,078	YU235525	48S11899H-15	316	682	61	83	164	4.8	53	126	29	5	804	1808	3.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11899H-16	316	682	61	83	164	4.8	53	126	29	5	804	1808	3.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11899H-17	316	682	61	83	164	4.8	53	126	29	5	804	1808	3.3	
11GA / 48" X 120"	1	1,862	3,642	YU139676	48S14905A-112	306	656	61	84	166	6	48	111	29	11	805	1825	2.2	
11GA / 48" X 120"	1	1,862	3,642	YU139676	48S14905A-113	306	656	61	84	166	6	48	111	29	11	805	1825	2.2	
TOTAL:		14	17,527	38,638															
Remarks: NO MERCURY CONTAMINATION Bend test: good for all Heat NO.																			
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS																			

P50908PC001V

YIEH MAU CORP.

Manager of Quality Assurance Section